

PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶: A23K 1/18	A1	(11) International Publication Number: WO 98/19560 (43) International Publication Date: 14 May 1998 (14.05.98)
(21) International Application Number: PCT/NO97/00279 (22) International Filing Date: 22 October 1997 (22.10.97) (30) Priority Data: 964645 1 November 1996 (01.11.96) NO (71) Applicant (for all designated States except US): NORSK HYDRO ASA [NO/NO]; N-0240 Oslo (NO). (72) Inventors; and (75) Inventors/Applicants (for US only): JOHNSEN, Freddy [NO/NO]; Grenseveien 28, N-1927 Rånåsfoss (NO). HJØRNEVIK, Leif [NO/NO]; St. Hansgt. 3, N-3714 Skien (NO). RINGDAL, Ole [NO/NO]; Korpeliveien 35, N-3928 Porsgrunn (NO). (74) Agent: SUNDNES, Arne; Norsk Hydro ASA, N-0240 Oslo (NO).		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>
(54) Title: METHOD FOR PRODUCTION OF FEED FOR SALMONIDES AND FEED FOR SALMONIDES (57) Abstract <p>The invention relates to a method for production of fish feed comprising fish products and standard feed components and fish feed products. Ammonium-, sodium- or potassium diformates, comprising formic acid or mixtures thereof are included in the fish products prior to their further processing and mixing with the other feed components. The final fish feed contains preferably 0.3-2.5 weight % formates based on the total feed.</p>		

BEST AVAILABLE COPY

B11

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Switzerland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

Method for production of feed for salmonides and feed for salmonides

The present invention relates to a method for production of feed for salmonides, like Atlantic salmon or rainbow trout, comprising processing fish products and standard feed components. The invention also comprises fish feed containing fish products and standard feed components.

Within the aquaculture industry there is a continuous search for improved feeds which will increase growth rate, feed utilisation, digestibility of protein and fat, etc. Within the field of animal feed there are known several types of additives to feeds which increase the growth rate for i.a. pigs and piglets. Among such additives are various types of formates, described in the unpublished patent application PCT/NO96/00114. However, addition of formates to fish feed has been found to have no effect.

The main object of the invention was to arrive at improved fish feed, comprising fish products, which would increase the growth rate, the digestibility of protein and fat and feed utilisation of the fish.

Another object was to obtain an improved feed for salmonides like Atlantic salmon and rainbow trout.

A further object was to arrive at a fish feed utilising the positive effects of feed additives used in animal feed.

Based on the positive results obtained by animal feed comprising formates, as described in the above stated application, the inventors started by composing a fish feed comprising fish products and standard fish feed components, and then incorporated minor amounts of various types of formates and/or formic acid. Such a feed was then fed to Atlantic salmon fingerlings in fresh water. The fish products could be fish meal or oil, fish remains commonly used in fish feed and minced fish.

The applied formates, comprising diformates, comprise sodium-, ammonium, and potassium formate. Mixtures of said formates, with and without added formic acid, are also applicable. Potassium diformate, possibly mixed with formic acid, was found to be especially useful.

The diets used were the following:

One diet containing 1 weight% 85% formic acid (Positive Control, PC), three diets containing 1.3 weight% different formates and one diet with no formic acid addition (Negative Control, NC).

The results of these tests were rather disappointing as the growth rate of the salmon fingerlings fed with diets containing formates or formic acid was lower than for those getting the negative control diet. However, some positive results were recorded. Thus, the digestibility of protein and fat was recorded to be higher when the diets contained formates or formic acid.

The lower growth and feed intake due to inclusion of formic acid or formates, and the higher nutrient digestibility, indicates that the lower feed utilisation efficiency for these diets was due to lower feed intake rather than reduced nutrient digestibility or other factors effecting nutrient utilisation efficiency. The main reason for reduced feed consumption may have been the taste of the acidified feed.

In view of the negative effects, especially with regard to growth rate, the inventors started looking for new ways of including the additives which after all seemed to have some positive effects. Different methods of producing the feed comprising addition of the additives at different stages of the production of the feed were then investigated. The most promising route seemed to be incorporation of the additives in the fish products prior to their further processing together with the other components of the final feed. The formates could be included in the fish raw material, for instance during storage or during processing to feed intermediates like fish meal or oil.

A new set of diets comprising corresponding negative- and positive control diets and diets comprising diformate were made by incorporation of the diformate and formic acid in the fish products which subsequently were further processed to fish feed in a conventional process. These diets were then fed to Atlantic salmon in sea water. It was then most surprisingly found that the new diets containing diformates resulted in increased growth compared with the control diets. Higher energy and protein digestibility were also recorded during these experiments for the diets containing formates.

Thus it was found that improved fish feed, comprising fish products and standard feed components, could be made by including ammonium-, sodium- or potassium diformates, comprising formic acid or mixtures thereof in the fish products prior to their further processing and mixing with other feed components.

The diformates were preferably included in the fish product, in amounts of 1-5 weight% prior to mixing and process it with the other feed components, in amounts resulting in 0.3-0.5 weight% formates, based on the total feed. The preferred fish product would be fish meal and the preferred diformate applied would be potassium diformate.

The new improved fish feed, comprising fish products and standard feed components, contained at least one fish product component having included therein before its mixing with the other feed components, ammonium-, sodium- or potassium diformate or mixtures thereof. This new feed contained preferably 0.3-2.5 weight% formates and/or formic acid based on the total feed.

The scope and special features of the invention are as defined in the attached claims.

The invention is further described and explained in the following examples.

Example 1

This example shows the effects on Atlantic salmon fingerlings in fresh water when fed with different types of diets, with and without formates and formic acid.

The salmon's had an average weight of 30 grams and were distributed in 15 m³ fibreglas tanks supplied with fresh water. Each tank contained about 200 fish, giving a total weight of 6 kilo grams in each tank. The temperature during the test was on the average about 9 °C.

The diets were produced with a twin screw extruder. The formic acid and the formates were added to the diets before extrusion. All the formulated products were extrusion stable. The formic acid (85%) was added by spraying into the mash during mixing and was added at a 1 weight% level. The formates were added at a 1.3 weight% level, in order to achieve corresponding amounts of formates as from formic acid. The diets were a negative control (NC) without any formic acid, a positive control (PC) with formic acid (diet 1) and 3 diets containing different formates. All diets were based on the same ground mix consisting of fish meal, fish oil, grounded wheat, digestible starch, pigment, minerals and vitamins. To all diets there were added 85 mg/kg yttrium oxide (Y₂O₃) as an indicator for digestibility.

The following diets were used during the experiments, Table 1.

Table 1

Diet Number	Additive	Inclusion level %	Formates %	Dry matter %
1	Formic acid	1	0.74	93.8
2	Formate 1	1.3	0.77	93.8
3	Formate 2	1.3	0.93	93.8
4	Formate 3	1.3	0.80	93.8

The composition of the formates used was as shown in Table 2.

Table 2

Component	Formate 1	Formate 2	Formate 3
Potassium diformate	88%	49.3	49.3
Trisodium tetraformate		24.6	17.2
Sodium diformate			32.0
Calcium formate	10.5	24.6	
Water	0.5	0.5	0.5
Silicate	1.0	1.0	1.0
Total Formate	68.2	69.0	71.9

The chemical composition of dry diets was as shown in Table 3.

Table 3

Nutrient	Content Dry Pellets %
Protein	51.2
Fat	24.3
NFE	15.5
Ash	8.5
Water	6.2
Indicator	85 ppm

The fish fed dry feed were fed by automatic feeders ad-lib in period 1 and iso-energetically according to biomass in period 2. The fish were fed 24 hours per day at intervals of 15 minutes. Feed intake measurements were done by daily collection of excess feed. Feed intake was the difference between distributed feed and feed collected. At the end of period 2 the apparent digestibility of the dietary fat and protein was determined according to Austreng (1978) and Maynard (1978). The average weight of the salmon was 50 grams varying from 40-65 grams. There was no mortality during the experiments.

The specific growth rate (SGR) for periods 1 and 2 and weight increase (WI) in grams/day for the same periods are shown in Table 4.

Table 4

Diet	Diet No.	SGR-1 %	SGR-2 %	SGR-tot. %	WI-1 g/day	WI-2 g/day
NC	5	0.96	1.04	0.99	11.14	13.63
PC	1	0.40	0.73	0.55	4.27	7.66
Formate-1	2	0.43	0.76	0.58	4.62	7.95
Formate-2	3	0.41			4.24	
Formate-3	4	0.53			5.67	

The salmon grew more slowly during period 1 than in period 2. Fish fed feed without formic acid grew better than fish fed diets with added formic acid (PC) or formates. There was a clear drop in feed intake in the treatments with acidified feeds in the diets. Each fish fed the negative control diet consumed on the average 11.9 grams feed during period 2 compared to 8.2 and 8.1 grams/fish for fish fed diets containing formates or formic acid, respectively.

The recorded digestibility in % for fat and protein and feed conversion ratio (FCR) for period 1 and 2 are shown in Table 5.

Table 5

Diet	Diet No.	Protein %D	Fat %D	FCR-1	FCR-2
NC	5	89.93	97.03	1.14	0.87
PC	1	91.55	97.74	2.38	1.06
Formate-1	2	90.93	97.13	2.18	1.03
Formate-2	3			2.19	
Formate-3	4			1.99	

Fish fed diets with formates or formic acid had significantly higher protein digestibility than fish fed negative control diets.

Example 2

Potassium diformate was included into the feeds either prior, (one day), to fish meal production (F 1) or prior to feed production (F 2). The trials were conducted with Atlantic salmon, weighing about 650 grams at start, for 80 days. The fish were allocated in 1 m³ fibreglas tanks supplied with sea water, with 24 fish in each tank. The fish were fed ad-lib 24 hours a day at 15 minutes intervals. The

trial was divided into three periods of 28, 28 and 24 days, respectively. The fish were fed, in triplicate, ad libitum and the feed losses were recorded every day. A control diet (Control) without addition of formate was also part of the trial. The diets were produced on a twin screw extruder. All dry ingredients were mixed together prior to extrusion, and the oil was added posterior to drying in a fluid bed.

The formate used during the tests had the following composition shown in Table 6:

Table 6

Composition	Formate-4 %
Potassium diformate	98.7
Water	0.3
Silicate	0.1
Total Formate	68.3

The proximate composition of the fish meals are shown in Table 7.

Table 7

Composition	Standard	With Formate-4
Crude protein %	75.2	75.2
Water %	4.5	4.8
Ash %	9.7	11.0
Fat %	10.4	8.8
Salt (NaCl) %	0.77	0.81
TVN ¹ %	0.12	0.14
Potassium %	1.3	2.2
Formate-4 %	0	2.7

TVN¹ Total volatile Nitrogen.

Composition and analysed chemical content in the experimental diets are given in Tables 8 and 9, all figures are given i %.

Table 8

Composition	Control	F-1	F-2
Fish meal, standard	49.68	0	49.98
Fish Meal with Form.	0	49.83	0
Fish oil	24.85	25.65	24.8
Wheat	20.3	19.4	18.5
Water	4.4	4.35	4.6
Formate	0	0	1.3454
Vitamin premix	0.5	0.5	0.5
Mineral premix	0.2	0.2	0.2
Pigment	0.07	0.07	0.07

Table 9

	Control	F-1	F-2
Dry matter	96.3	94.4	96.4
Protein	45.4	44.5	45.9
Fat	29.6	29.7	30.7
Ash	6.1	6.3	6.5
NFE ¹	15.2	13.9	13.3
Gross energy, MJ/kg	24.8	24.4	24.8

NFE¹ Dry-matter = protein + fat + ash

The results of the experiments are shown in the following tables. Table 10 shows the growth increases from start weight in grams to the weights at the end of periods 1- 3.

Table 10

Diet	Start weight	Weight Period 1	Weight Period 2	Weight Period 3
Control	650.3	831.7	1059.0	1219
F-1	652.1	835.7	1093.3	1303
F-2	648	816	1022	1180

As can be seen from table 10 the growth of salmons fed with diets containing diformates included in the fish meal prior to the production of the feed (F-1) was significantly higher than when the formate was added during the production of the feed (F-2). The latter diet resulted in fact in a lower growth than when the fish were fed with the Control diet. This confirms the results from example 1.

The digestibility of fat, protein, dry matter (DM), ash NFE and gross energy in Atlantic salmon fed either control diet or diets F-1 or F-2 are shown in Table 11.

Table 11

Diet	Fat	Protein	DM	Ash	NFE	Energy
Control	96.4	90.1	77.9	3.9	35.3	88.5
F-1	97.0	91.1	79.3	14.0	33.9	89.8
F-2	96.3	91.0	79.1	7.2	33.7	89.5

The digestibility of protein, dry matter and energy was significantly higher for diets F-1 and F-2 than for the Control diet. The digestibility of ash was three-fold higher for F-1 than for Control and F-2.

The above experiments clearly show that it is essential at what stage of the feed production the diformate comprising formic acid is included. In order to obtain the above positive results with regard to growth increase, digestibility of fat and protein etc. the diformate comprising formic acid should be included in the fish product component of the feed prior to further processing this component together with the other components into the final feed. The amount of formate and formic acid to be included in the fish product component depend on the relative amount of this component in the final feed. The amount of fish products may be varied within wide limits, for instance from 20-60 weight% of the total feed. Said amount, calculated on a formate basis, of the total feed should be in the range of 0.3-2.5 weight%.

Claims

- 1 Method for production of fish feed, comprising fish products and standard fish feed components,
characterized in that
ammonium-, sodium-, or potassium diformate, comprising formic acid, or mixtures thereof are included in the fish products prior to their further processing and mixing with the other feed components.
2. Method according to claim 1,
characterized in that
the diformates are included in fish products in amounts of 1-5 weight%, prior to its application in the feed, and that the fish products were mixed with the other feed components in amounts resulting in 0.5 -2.5 weight% formates, based on the total feed.
3. Method according to claim 1,
characterized in that
potassium diformate is included in fish meal in amounts of 1-1.5 weight%.
4. Method according to claim 1,
characterized in that
fish remains or minced fish preserved with diformates are mixed with the standard feed components and processed into fish feed.
5. Fish feed comprising fish products and standard feed components,
characterized in that
the fish products contain ammonium-, potassium- or sodium diformate, comprising formic acid, or mixtures thereof, and comprises 20-60 weight% of the total feed.

6. Fish feed according to claim 5,
characterized in that
the fish products contain 1-5 weight% formates and/or formic acid
resulting in amounts of 0.3 - 2.5 weight% based on the total feed.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/NO 97/00279

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: A23K 1/18

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: A23K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI, JAPIO

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X ✓	GB 1505388 A (BP CHEMICALS LIMITED), 30 March 1978 (30.03.78)	1-6
X ✓	EP 0009366 A1 (BP NUTRITION (UK) LIMITED), 2 April 1980 (02.04.80)	1-6
A	US 4338336 A (ELMER F. GLABE ET AL), 6 July 1982 (06.07.82)	1-6
	<i>nicht relevant beschreibt sodium diacetate</i>	



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

18 February 1998

Date of mailing of the international search report

19 -02- 1998

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. +46 8 666 02 86

Authorized officer

Dagmar Järvman
Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.
PCT/NO 97/00279

Patent document cited in search report			Publication date	Patent family member(s)	Publication date
GB	1505388	A	30/03/78	AU 1963276 A	25/05/78
				BE 848712 A	24/05/77
				BR 7607815 A	11/10/77
				DD 127475 A	28/09/77
				DE 2653448 A,C	07/07/77
				DE 2653449 A	08/06/77
				DK 156534 B,C	11/09/89
				DK 530276 A	28/05/77
				DK 530376 A	28/05/77
				FR 2332764 A,B	24/06/77
				JP 1145271 C	12/05/83
				JP 1188031 C	30/01/84
				JP 52070993 A	13/06/77
				JP 52110286 A	16/09/77
				JP 58011921 B	05/03/83
				LU 76270 A	10/07/78
				NL 184763 B,C	01/06/89
				NL 185703 B,C	01/02/90
				NL 7612827 A	01/06/77
				NL 7612828 A	01/06/77
				SE 424805 B,C	16/08/82
				SE 7612195 A	28/05/77
				US 4179522 A	18/12/79
				ZA 7606293 A	30/05/78
EP	0009366	A1	02/04/80	SE 0009366 T3	
US	4338336	A	06/07/82	CA 994240 A	03/08/76
				US 3925559 A	09/12/75
				US 4161543 A	17/07/79
				US 4299854 A	10/11/81

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ BLACK BORDERS
- ☐ IMAGE CUT OFF AT TOP, BOTTOM OR SIDES
- ☐ FADED TEXT OR DRAWING
- ☐ BLURRED OR ILLEGIBLE TEXT OR DRAWING
- ☐ SKEWED/SLANTED IMAGES
- ☐ COLOR OR BLACK AND WHITE PHOTOGRAPHS
- ☐ GRAY SCALE DOCUMENTS
- ☒ LINES OR MARKS ON ORIGINAL DOCUMENT
- ☐ REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY
- ☐ OTHER: _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.